

Work Order ID 78980

\*78980\*

Tuesday, January 17, 2012 3:00:28 PM

Ship to Jaym

Page 1

Item ID: D212-725-1-245

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Cam

Stop

\*NS2\*

Start Date: 1/17/2012 Start Qty: 3.00

\*3\*

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 3.00

\*3\*

Customer:

Reference:

Approvals: Process Plan: UMF

Date: 12-01-17 Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D212-725-1	G-PRELIM

100

\*100\*

Bandsaw

Jaspa Bandsaw

Memo

0.00

29 12-1-24

3 4

Cut blanks 3.250" long

110

\*110\*

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

29 12-1-24

3 4

Machine as per folio FA844 and DWG

Folio rev: 1A

Dwg Rev: 1

Deburr as per Dwg

E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC	QC2- Inspect parts off machine FAI/FAIB	0.00	RG	12-1-24		3	4		
Quality Control	Memo	0.00							

130

**\*130\***

Mill Conv

Conventional Milling Machine

Memo

Drill &amp; tap as per Dwg

0.00

RG 12/01/24

3

140

**\*140\***

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

RG 12/01/24

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

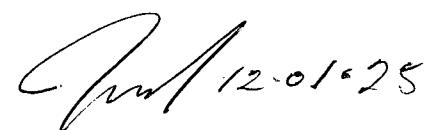
**\*150\***

QC

Quality Control

QC8- Inspect parts - second check

0.00




160

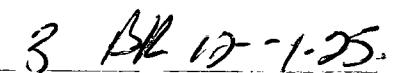
**\*160\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00



170

**\*170\***

QC

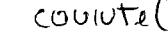
Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 78980**

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Page 4

Item ID: D212-725-1-245

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Cam

Stop

**\*NS2\***

Start Date: 1/17/2012 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

**\*180\***

Small Fab

Small Fab

Memo

Insert Helicoil as per Dwg

0.00

88

0.00

FF 12-01-25

3

190

**\*190\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

51210126

(X3)

200

**\*200\***

Packaging

Packaging

Identify as per dwg & Stock Location: 382

0.00

Memo

0.00

12/1/2012 32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**Work Order ID 78980****\*78980\***

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Tuesday, January 17, 2012 3:00:28 PM

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Start

**\*NS1\***

Revision ID:

Item Name: Cam

Stop

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Required Date: 1/27/2012 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
Description

210

QC21- Final Inspection - Work Order Release

**\*210\***

QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

Memo

12/1/2012

U (2-01, 26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Tuesday, January 17, 2012 3:00:27 PM

Page 1

Work Order ID: 78980

Parent Item: D212-725-1-245

Start Date: 1/17/2012

Required Date: 1/27/2012

Parent Item Name: Cam

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21209F1-15 HELI COIL		Purchased	No			160	Each	2.0000	2	6			

Location	Loc Qty	Loc Code
----------	---------	----------

ST304

2

Loc Code

104537

120308

6x

100

2

f

0.5000

0.3

0.9473684

EF 01-01-25  
12-01-23

Location	Loc Qty	Loc Code
----------	---------	----------

MAT002

Loc Qty

0.5

Loc Code

114351

0.5

.750x2.50  
Just 01.21  
This batch only

M 17 037

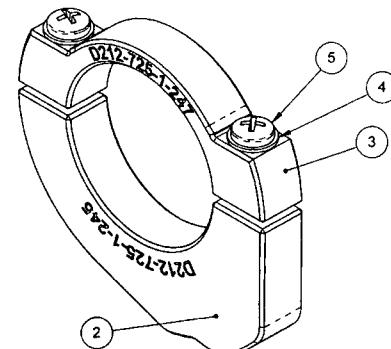
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D212-725-1-947	CAM ASSEMBLY
2	1	D212-725-1-245	CAM BASE ASSEMBLY
3	1	D212-725-1-247	RETAINER
4	2	NAS1149D0332J	WASHER
5	2	MS27039-1-15	SCREW



D212-725-1-947 CAM ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.21 lbs

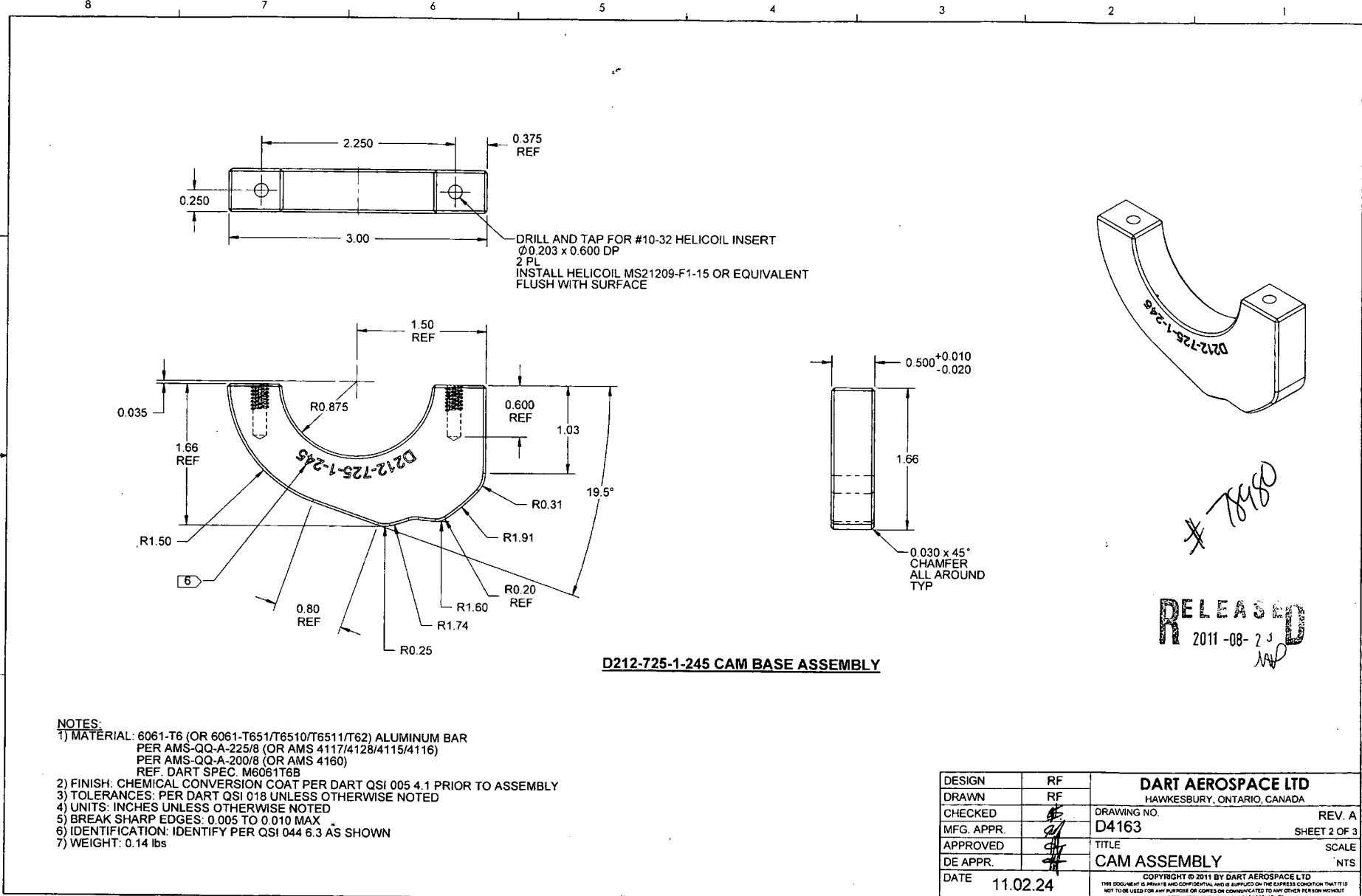
A	NEW ISSUE	RF	11.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AS</i>	D4163	SHEET 1 OF 3
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	CAM ASSEMBLY	NTS
DATE	11.02.24	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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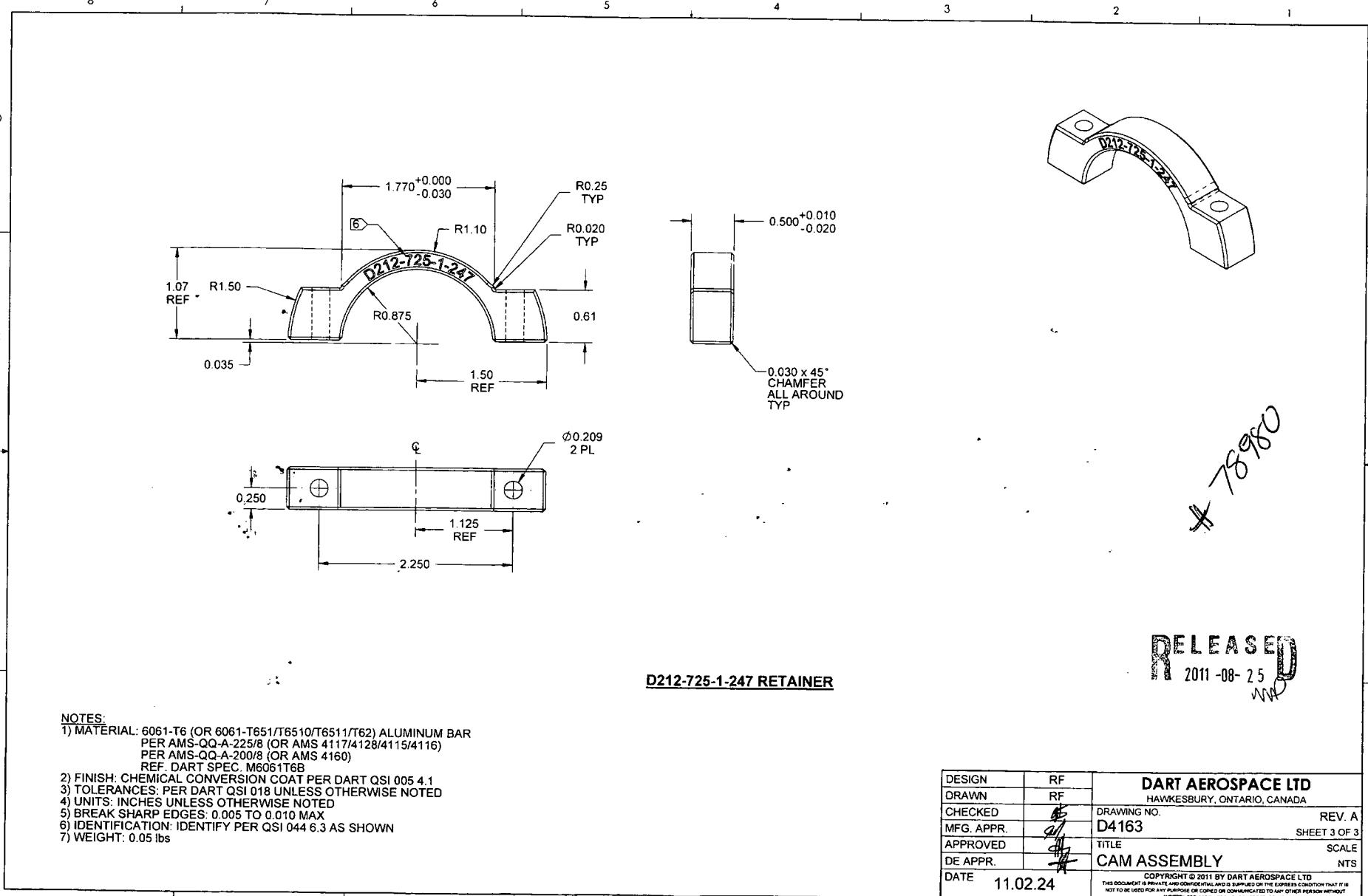


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DART AEROSPACE LTD	Work Order:	78280
Description: CAM BASE ASSEMBLY	Part Number:	212 725 245
Inspection Dwg:	Rev: A	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

1  
27.01.26

Measured by:	 / 	Audited by:		Preliminary Approval:	
Date:	12.1.24	Date:	 12-01-24	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15